

# Work Order ID 65623

January 20, 2011 11:45:23 AM



Page 1

Item ID: D4018-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Lid Assembly (350 )

Start Date: 1/21/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4018

C

100

Weld per dwg A/R S.S. rod Batch: *111585* 0.00



Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D4018 using DT9607B  
2- weld hinge (3) and Mounting brackets as per dwg D4018  
\*\*\*inspect before welding mesh\*\*\*  
3- tack weld mesh on basket as per dwg D4018  
\*\*\*make sure to place mesh correctly on lid, check with label plate before  
tacking mesh\*\*\*

*Pl 11.02.03*

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

*11/02/04*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 65623

January 20, 2011 11:45:24 AM



Page 2

Item ID: D4018-041

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Item Name: Short Basket Lid Assembly (350)

Start Date: 1/21/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*Sulab*



130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

*M112588*

Memo

0.00

Powder Coating

\*\*\* mask sides of hinge prior to powdercoat\*\*\*

Start Time:

Oven Temperature:

Finish Time:

*7:26 320° 8:10*

*1 BR 11-02-7*

140

Wing Walk as per dwg QSI005 4.4 Batch

0.00



HandFinish

Memo

0.00

Hand Finishing

- ✓ 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg
- ✓ 2- install label

*1 11/02/10*

W/O:		WORK ORDER CHANGES					
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**Work Order ID 65623**

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Page 3

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Start Date: 1/21/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

5/10/2010

10

160

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

use on w/o 65932

Memo

0.00

Packaging

D40326041

=&gt; let

11/02/08

19

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/08

ME

11-02-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

January 20, 2011 11:45:22 AM

Page 1

Work Order ID: 65623

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 1/21/11

Required Date: 2/04/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
* D4018-1 Rib		Manufactured	No			100	Each	2.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				2					
					59252			2					
✓ D4018-3 Rib		Manufactured	No			100	Each	2.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				2					
					59253			2					
✓ D4016-3 Hinge Half, Lid		Manufactured	No			100	Each	8.0000	3	3			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				8					
					64845			8					
✓ D4018-5 Rib		Manufactured	No			100	Each	16.0000	6	6			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				16					
					64067			16					

2  
Cpl 11.02.01  
65915  
~~365918~~ → (2)

2  
Cpl 11.02.01  
365918 → (2)

3  
Cpl 11.02.01  
365425 → (3)

6  
Cpl 11.02.01  
(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



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Work Order ID: 65623

Parent Item: D4018-041


Parent Item Name: Short Basket Lid Assembly (350 )

Start Date: 1/21/11

Required Date: 2/04/11

Start Qty: 1.00

Required Qty: 1.00

✓ D4035-041 Manufactured No 100 Each 1.0000 1  
  
 Lid Rib Assembly, Fwd (350 Basket)


Location Loc Qty Loc Code

WA 1  
 64849 1

✓ D4035-043 Manufactured No 100 Each 1.0000 1  
  
 Lid Rib Assembly, Aft (350 Basket)

Location Loc Qty Loc Code

WA 1  
 64850 1

✓ D2581 Manufactured No 100 Each 33.0000 2  
  
 Mounting Bracket

Location Loc Qty Loc Code

WA 33  
 64112 20  
 64425 13

✓ D4020-7 Manufactured No 100 Each 0.0000 1  
  
 Mesh (350 Basket Short, Lid)

✓ D4021-3 Manufactured No 100 Each 3.0000 1  
  
 Data Plate

Location Loc Qty Loc Code

WA 3  
 56050 1  
 64924 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

Page 3

January 20, 2011 11:45:23 AM

Work Order ID: 65623



Parent Item: D4018-041



Parent Item Name: Short Basket Lid Assembly (350 )

Start Date: 1/21/11

Required Date: 2/04/11

Start Qty: 1.00

Required Qty: 1.00

D2728-3

Manufactured No

140

Each

0.0000

1

1



Dart Logo label

(x1) M115050



HL 11/02/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

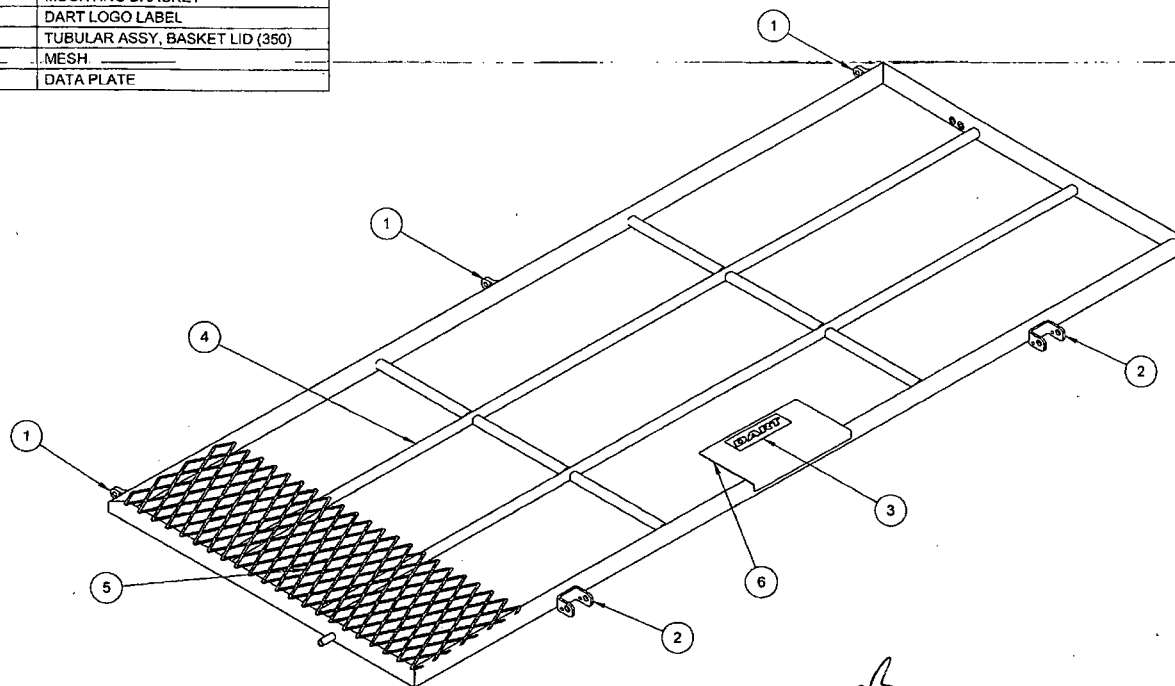
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE

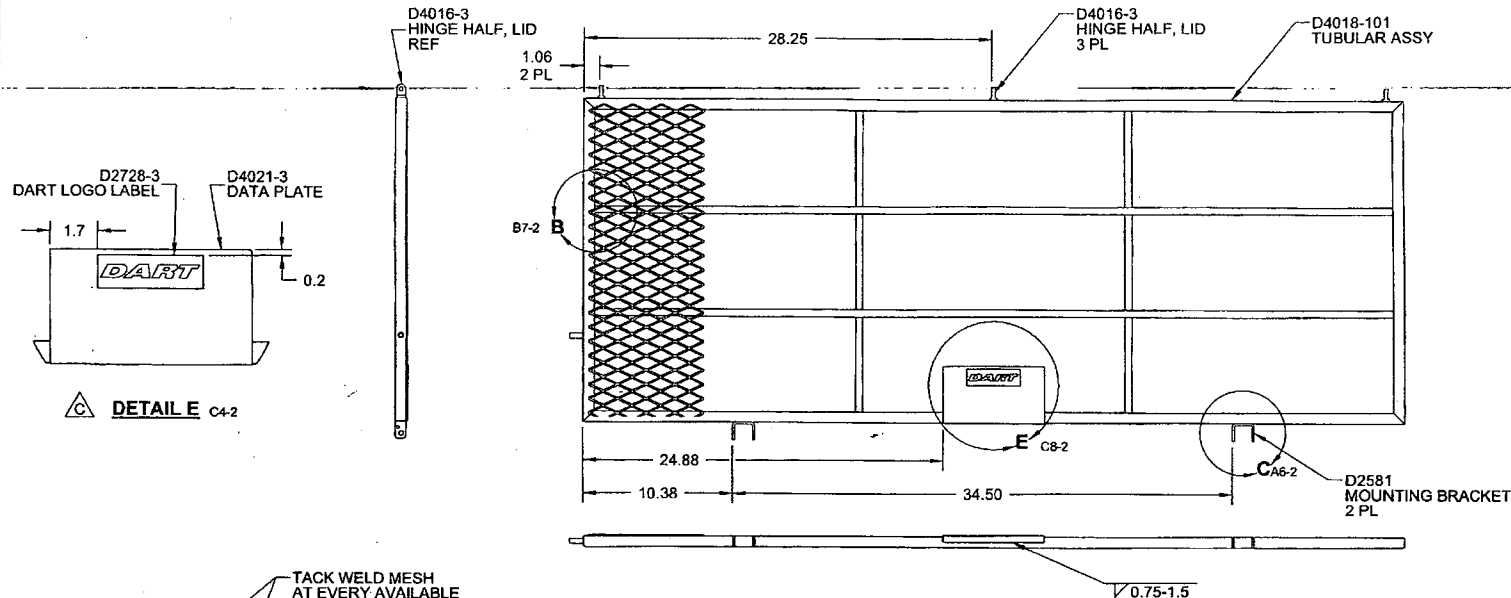


**D4018-041 SHORT BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

*also 65623*

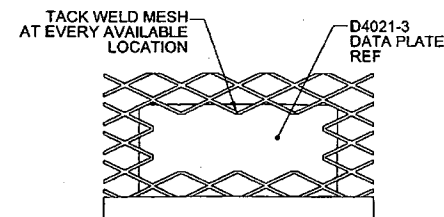
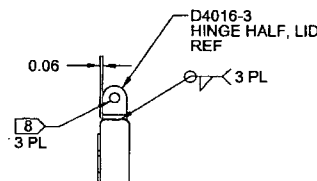
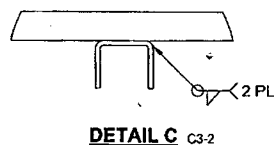
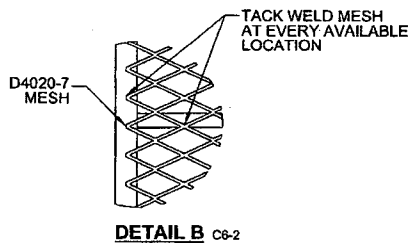
**RELEASED**  
10.08.12.4  
ECIS 10-946

C	REMOVED D4086-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4086-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D4018</b> REV. C SHEET 1 OF 4 TITLE <b>SHORT BASKET LID ASSY (350) NTS</b> <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	AS		
APPROVED	AS		
DE APPR.	AS		
DATE	10.08.05		



**D4018-041 SHORT BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED  
10.08.12



**VIEW A-A** C1-2

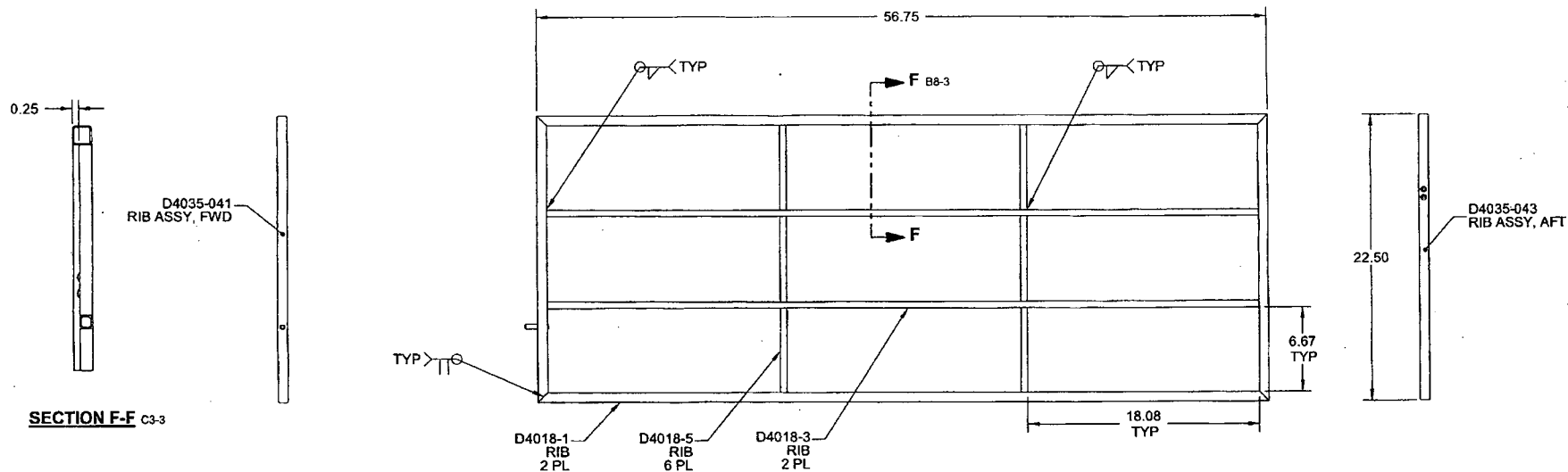
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.5 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

**DETAIL D** D1-2

DESIGN	ABS	<b>DART AEROSPACE LTD</b>	
DRAWN	B	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	AW	<b>D4018</b>	SHEET 2 OF 4
APPROVED	AW	TITLE	SCALE
DE APPR.	AW	<b>SHORT BASKET LID ASSY (350)</b> NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR ORIGIN OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



**D4018-101 TUBULAR ASSY, BASKET LID (350)**

**RELEASED**  
10.08.12

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO. D4018	REV. C
MFG. APPR.	SC	SHEET 3 OF 4	
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	<b>SHORT BASKET LID ASSY (350)</b>	NTS
DATE	10.08.12	<small>           COPYRIGHT © 2012 BY DART AEROSPACE LTD            THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE CONDITION THAT IT IS            NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT            WRITTEN PERMISSION FROM DART AEROSPACE LTD.         </small>	